

Work Order ID 53841

November 19, 2009 11:24:14 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 19/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *by*

Date: 09-11-09 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2512	Rev E								

100 Weld per dwg A/R S.S. rod Batch: H109213 0.00

Large Fab

Large Fab

Memo 0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 ✓

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-Weld as per Dwg D2512 using Welding Jig DT 9436

Deburr as required

INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

PD 09.11.27

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

Cpl 09/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

=> Solubso

(1)

4

QC

Memo

0.00

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

PRESOAK WASH =>

BK 09-11-30 ⑪

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 11:00

OVEN TEMPERATURE: 400°

FINISH TIME: 11:30

2ND COAT:

START TIME: 12:00

OVEN TEMPERATURE: 400°

FINISH TIME: 12:30

BK 09-11-30 ⑩

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



HandFinishing

0.00

X1

HandFinish

Memo

0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4
Batch: M112437(BLACK PAINT)

M112623(Wingwalk)

MD 09/12/01

M112594(Black Paint)

150



QC3- Inspect Part Finish

0.00

M1 09/12/01

QC

Memo

0.00

Quality Control

160



Identify as per dwg & Stock Location:

0.00

MD 09/12/01

Packaging

Memo

0.00

Packaging

w/o 53839

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/03 AF

B109-12-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Page 1

November 19, 2009 11:24:21 AM

Work Order ID: 53841



4

Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 19/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	20.0000	2.0000			

Clevis



N/A ✓
 Main Warehouse
 ST
 53881 350 ✓
 31101
 52498

WarehouseLocationLoc QtyLoc Code

20

2

18

ONLY APPLICABLE ON D130701-041

D2232-1RevC

Manufactured No

100 Each 16.0000 2.0000



Basket Hinge

WarehouseLocationLoc QtyLoc Code

Main Warehouse

ST

2

48230

2

Main Warehouse

WA

14

51105

14

PD 09.11.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Basket Lid 205/350

Start Date: 19/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1RevD		Manufactured	No			100	Each	31.0000	2.0000			

Spacer Bushing

Warehouse

Location

Main Warehouse

ST

Loc QtyLoc Code

31

ID 09.11.25

51331

6

52832

25

D2506RevF



Manufactured

No

100

Each

6.0000 1.0000



Label Plate

Warehouse

Location

Main Warehouse

ST

Loc QtyLoc Code

1

44275

1

Main Warehouse

WA

5

52834

5

ID 09.11.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Basket Lid 205/350

Start Date: 19/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	36.0000	2.0000			

Mounting Bracket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	12	
46086	2	
48428	1	
51120	9	

Main Warehouse

WA	24	
50872	1	
51745	23	

D3166-3RevA1

Manufactured

No

100 Each 4.1896 1.0000



Basket Hoop

DD 09.11.25

SAD 09.11.25

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

WA	4.189536842	
50033	0.0527	
50618	0.1894	
52058	3.94743684	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 19/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304EX0.75-16F



Purchased

No

100

sf

472.8421

18.9474



SAD

09-11-25

Expanded Metal Flat SS

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

MAT	472.8421065	
110134	3.4	
111630	1.85	
111956	0.000017	
112147	1.29428947	
112311	0.9205	
112707	26.6203	
112949	118.757	
113205	320	

18.8421

M304TS0.750W.065



Purchased

No

100

f

141.8802

45.8741



SAD 09-11-25

304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

MAT	137.9521	
113082	137.9521	

45.8741

Main Warehouse

WA	3.9280947	
112398	3.9280947	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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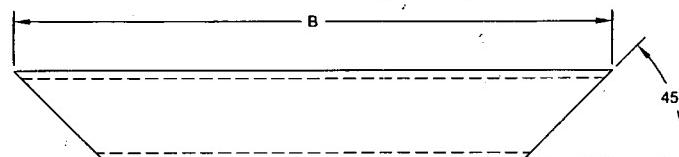
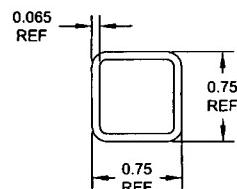
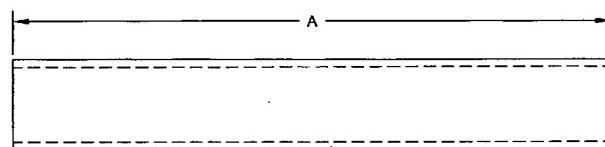
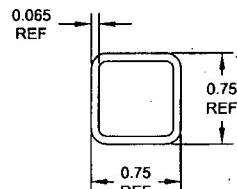
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

SHOP COPY

RETURN TO

ENGINEER

UNCONTROLLED DRAWING

SUBJECT TO APPROVAL

WITHOUT CHANGES

WORK ORDER

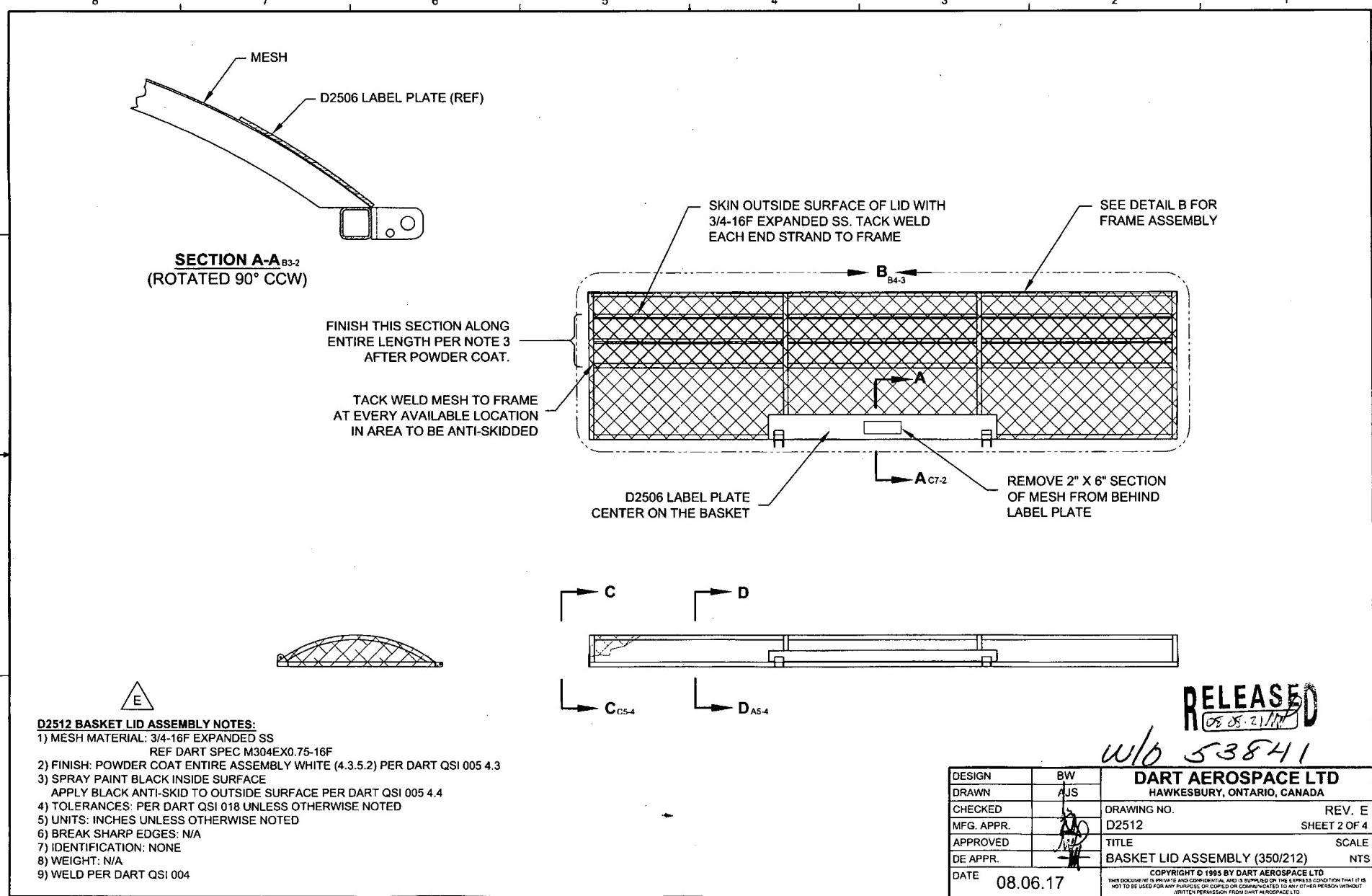
NO. 53841

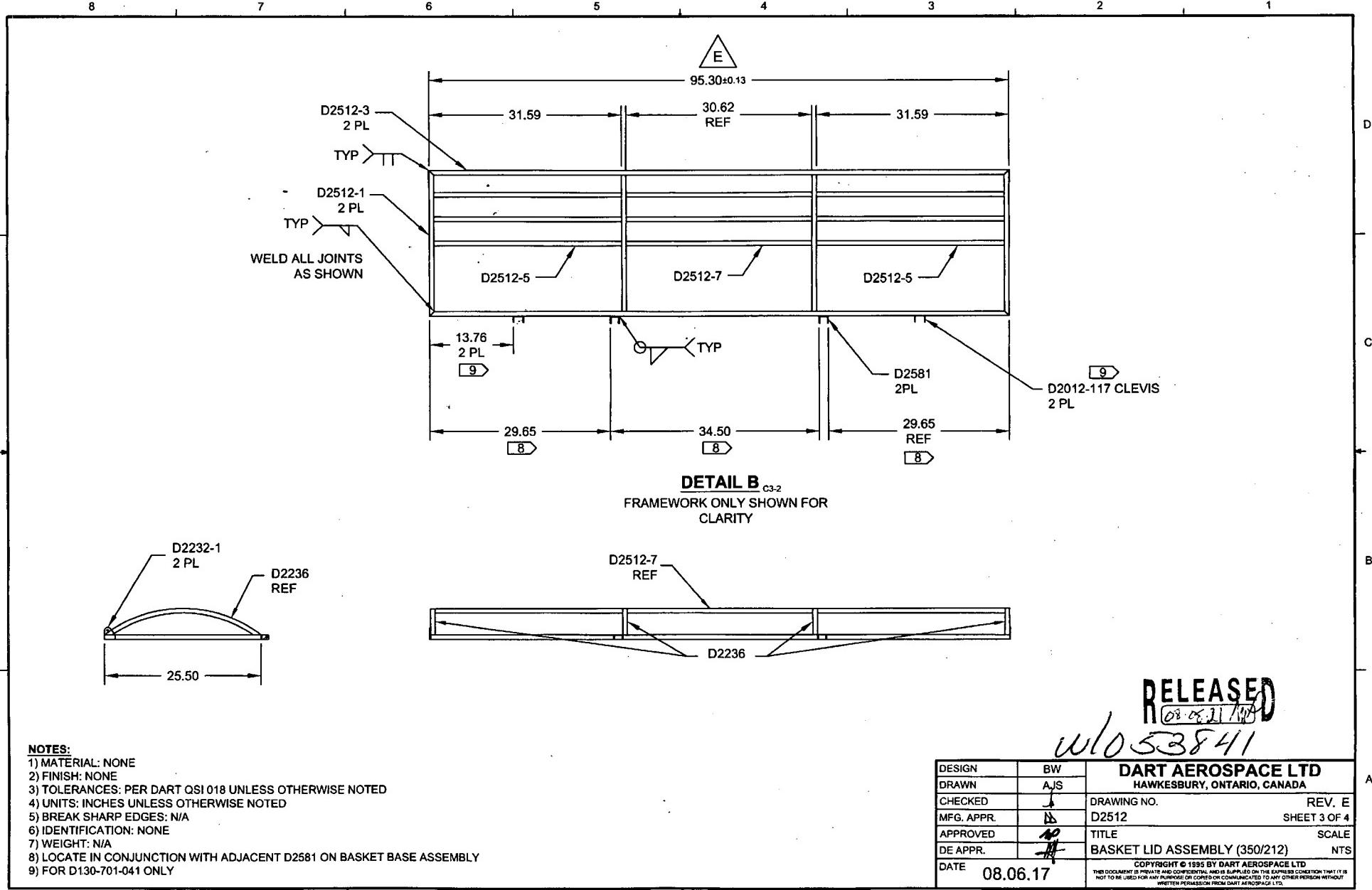
PL 09-11-19

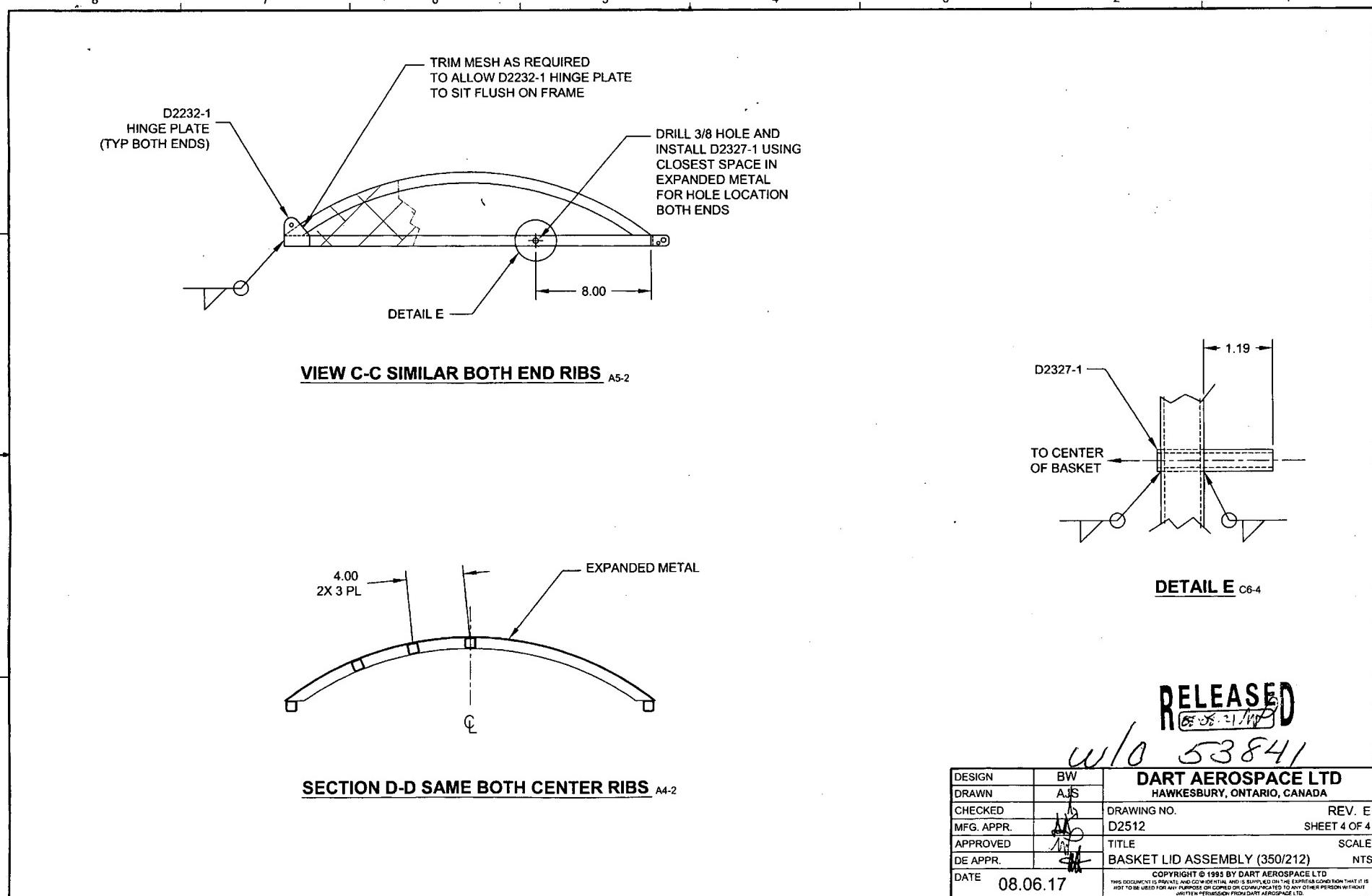
RELEASED

(08-08-21/14)

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3. ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. REV. E	
MFG. APPR.		D2512 SHEET 1 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212) NTS	
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	







DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D2512 SHEET 4 OF 4
APPROVED		TITLE SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212) NTS
DATE	08.06.17	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED
08-21-17

w/o 53841

